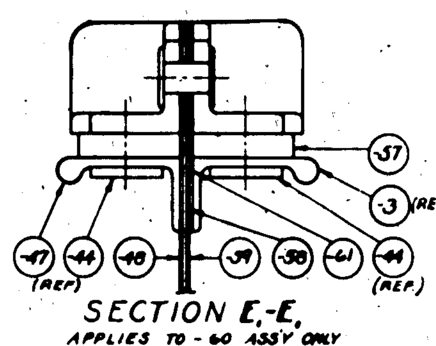
NOTE:
-57 - 1/? AL ALLOY SHT (REPLACES -27)
SAME AS -2, -6 & -25 EXCEPT 3/16" HEIGHT ADDED AT FORGING
-58 WEB (REPLACES -2)
-59 WEB (REPLACES -6)
-61 GUSSET (REPLACES -25)



SECTION E,-E,
APPLIES TO -60 ASSY ONLY

SECTION E-E
APPLIES TO -0 ASSY ONLY

-3 1 1/8 x 1 1/8 x 3/32 EXT BULB ANGLE DIE K778

-44 .188 x 3/8 EXTENDS FROM STA 4, 13" FWD

5 SPACES @ 2" TWO ROWS

4 SPACES @ 2" TWO ROWS

-5 10 3/8 x 1 x 1/2 TIE STRAP NOT TO BE ATTACHED UNTIL BLKH'D #3 (288100) IS INSTALLED

DO NOT DRILL FOR THESE 16 RIVETS UNTIL INSTALLATION OF BULKH'D #3 ON ASSEMBLY AN442-D8

RIVET PATTERN AT STA 3.66 SIMILAR TO STA 3.33 EXCEPT AS NOTED

EXF312 CLIP

AC425-D4

VIEW D-D

VIEW F

-27 .072 SHEET GUSSET

SECTION H-H
TYPICAL CONSTRUCTION

VIEW

-48 ADDITIONAL WEB .030 AL ALLOY (24 ST) L.H. FOR X-PBY-5A ONLY

-63 .035 WEB FOR -550 ASSY

NOTE -- -25 GUSSET AND KEEL WEBS EXTEND UP BETWEEN FITTINGS 288041 AS SHOWN. SEE SECTION

288041 L.H.
288041 R.H.
NOT TO BE ASSEMBLED UNTIL INSTALLATION OF BLKH'D

SEE SECTION EE & E,E,

NOTE -60 ASSY ONLY
-48 .030 WEB
-49 R.H. REPLACES -A.H. MAT'L OF -48, -49
-50 L.H. -20 -30, -31, -32, -33
-31 R.H. -33 -34, -35, & -36
-32 L.H. -34 L.H. 1 - 1/16 x 1/16
-33 R.H. -23 R.H. AL ALLOY
-34 L.H. -24 L.H. BULB ANGLE
-35 R.H. -33 R.H. DIE K 1298
-36 L.H. -32 L.H.
-57 -27 (FLUSH WITH EDGE) OF FORGING

NOTE -58, -59, & -61 SAME AS -2, -6 & -25 EXCEPT 3/16 HEIGHT ADDED AT POINT INDICATED DUE TO REPLACEMENT OF -27 WITH -57 GUSSET

MILL TAPER AS SHOWN

THIS ROW OF RIVETS TO BE DRILLED & ASSEM. OF KEEL TRUSS & BLKH'D #3 SEE 288300 - VIEW D-D

-2 .030 WEB EXTENDS FROM STA 3 TO STA 4. SEE -6 FOR ADDITIONAL WEB

-26 .072 x 3/4 x 1.064 SHEET

-43 .032 GUSSET REAR & FRONT

-42 .032 GUSSET REAR & FRONT

-25 .064 GUSSET

TRIM OUTSTANDING LEG 30°

THESE RIVETS LOCATED ON 4 BLKH'D - SEE DWG 288400 DETAIL 'A'

AN442-D6 AT ADDITIONAL WEB SPACED APPROX. AS SHOWN

THESE HOLES NOT TO BE DRILLED UNTIL ASSEM. WITH

SEE SECTION A-A FOR CUTOUT AT BELTFRAMES

TOP EDGE OF MIDDLE FLANGE KEEL SECTION 2M238 (REF)

BASE LINE

-6 ADDITIONAL .040 WEB L.H. SIDE FOR -0 & -60 ASSYS

-62 .061 WEB FOR -550 ASSY ONLY

JOGGLE 3/32 EACH SIDE

AT BELTFRAMES

AN442-D6 RIVETS DRIVEN ON INSTALLATION OF BELTFRAMES

-11 THICKNESS BELTFRAME WEB .125 - .555 ASSY

.125 - .555 ASSY
.11 THICKNESS BELTFRAME WEB

-12 L.H. / -11 R.H. PLAIN ANGLE

-10 L.H. / -9 R.H. PLAIN ANGLE

-14 L.H. / -13 R.H. PLAIN ANGLE

STRAP - 288039 INSTALLED WITH BELTFRAMES

CUTOUT IN KEEL SECTION FOR STRAP

288039-1
288039-7

KEEL SECTION 2M238 (REF)

SECTION A-A

PORT / STARBOARD

KEEL SECTION 2M238 (REF)

SECTION B-B
LOOKING FORWARD

SECTION C-C
FULL SIZE

FIRST RIVET ALL DIAGONALS & VERTICALS EXCEPT AT STATIONS AS SHOWN

TYPICAL CONSTRUCTION AT LOWER END OF VERTICAL AND DIAGONAL MEMBERS

RIVET NOTES:-
ALL RIVETS NOT LOCATED TO BE SPACED AT EQUAL INTERVALS AS SHOWN
RIVETS IN INTERMEDIATE VERTICALS & DIAGONALS TO BE AN442-D5 EXCEPT END RIVETS AS NOTED
FOR AN442-D6 USE 1/8 DIA DRILL
FOR AN442-D4 USE 1/8 DIA DRILL
FOR AN442-D6 USE 5/32 DIA DRILL
FOR AN442-D8 USE 1/4 DIA DRILL

FINISH:
2-P-20P - NWS ON PBY-1
2-P-20P - NWS ON PBY-2 & FUTURE

CONT. 70496 (25-167)

NOTE -60 ASSY SAME AS -0 CONT. 70496 (1-24) EXCEPT AS NOTED. -550 ASSY FOR PBY'S WITH BUILT-UP BELTFRAMES. -555 ASSY FOR PBY'S WITH PRESSED FRAMES

FINISH CODE	
Z	ANODIC TREATMENT
P	P-27 PRIMER
GP	GREEN PRIMER
C	CADMIUM PLATE

ALL AL ALLOY SHEET 24 ST SPEC 47A10 EXCEPT AS NOTED
ALL AL ALLOY EXTRUSIONS 24 ST EXCEPT AS NOTED
HEAT TREAT ALL 24 SO MATL TO 62000 LBS PER SQ INCH
RIVETS AL ALLOY 17 ST EXCEPT AS NOTED

[redacted]

CONSOLIDATED AIRCRAFT CORP.
BUFFALO, N.Y.

MATERIAL: NOTED
SPEC: NOTED
HEAT TREAT: NOTED
FINISH: NOTED

KEEL TRUSS HULL
STA.3 - STA.4

J 288043

R 288043